

Date: Thursday, 11/29/2007 11:06:55 AM
 User: Kim Johnston

Process Sheet

split 5
 08/01/02

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36040 - 2
 Estimate Number : 12712
 P.O. Number : N/A
 This Issue : 11/29/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL / MED FAB
 Previous Run : 35696
 Written By : Kim Johnston
 Checked & Approved By : Kim Johnston
 Comment : Est Rev:A New Issue 07-02-14 JLM

Drawing Name : WEARPAD
 Part Number : D35371
 Drawing Number : D3537 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 12/10/2007

Qty: 100 Um: Ear

38

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S16GA

304/316 .063 Sheet



8.5104



Comment: Qty.: 0.0788 sf(s)/Unit Total: 7.8750 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 105997 IB 07-12-6

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

IB 07-12-6

2-Deburr if necessary

IB 07-12-6

108

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-12-6



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7/12/06 108

5.0

BRAKE NC

NC BRAKE

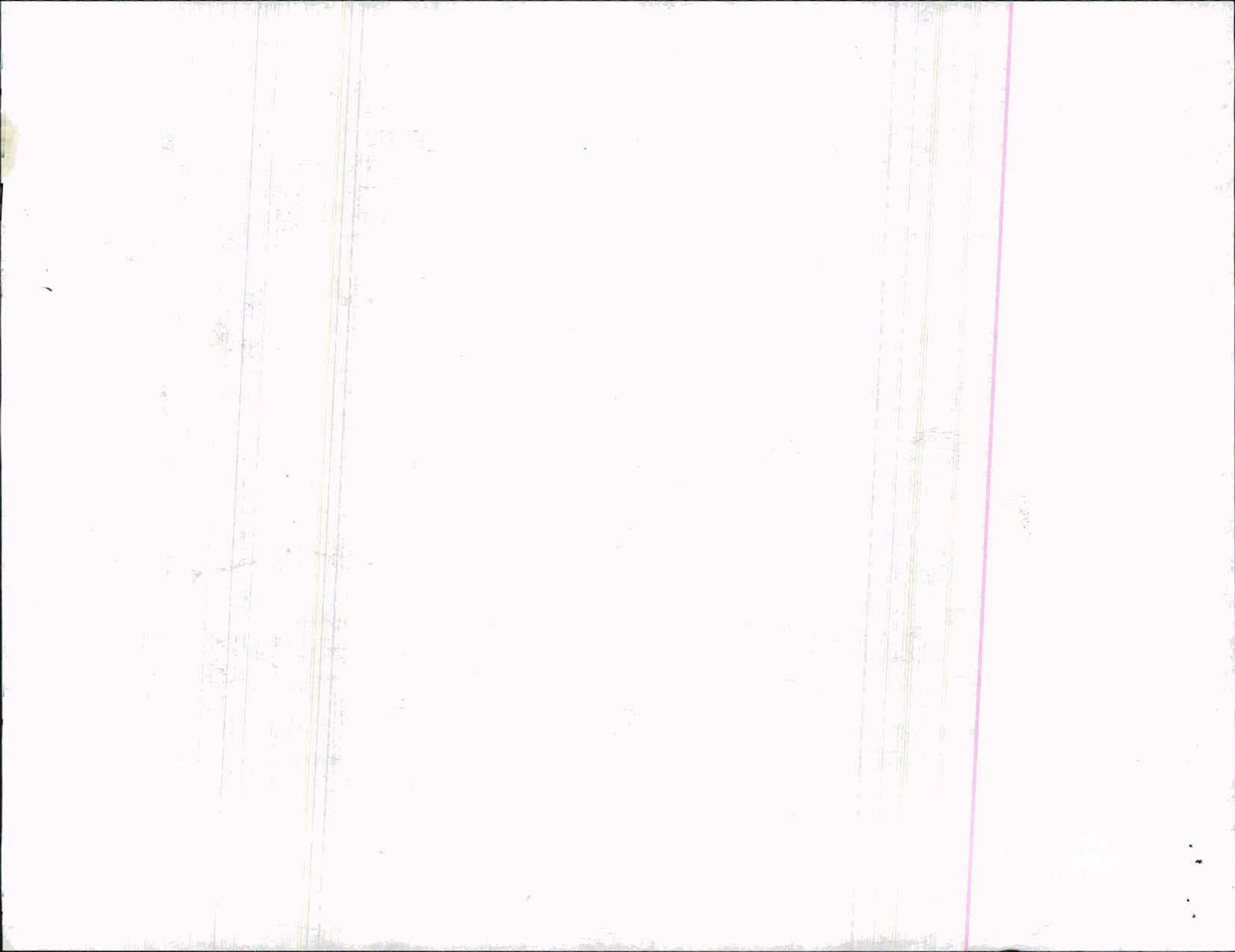


Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

07/12/11



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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 36040

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat M106390 / M105959
1-Weld as per Dwg D3537 using Jig DT 8210
2-Remove any weld that penetrated through Wearpad if necessary

HY 08/01/08 (20x)
HY 08/01/02 (38)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

HY 08/01/08 (20)

HY 08/01/02 (38)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

HY 08/01/08 (20)

HY 08/01/02 (38)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642 PL 08-01-08 (20)
M105642 FX 08/01/02 (38)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-02 (38)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP-20

EP-20 M-1 08/01/08 (20x)
MS 08-01-02 (38)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

HY 08/01/03 (20)

Job Completion



2008/1/2 38x
2008/1/8 20x

W 108 045

W 05-01-02

08.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/01/02	49.0	w/o was split for 38 pcs	✓	08/01/02	x38		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

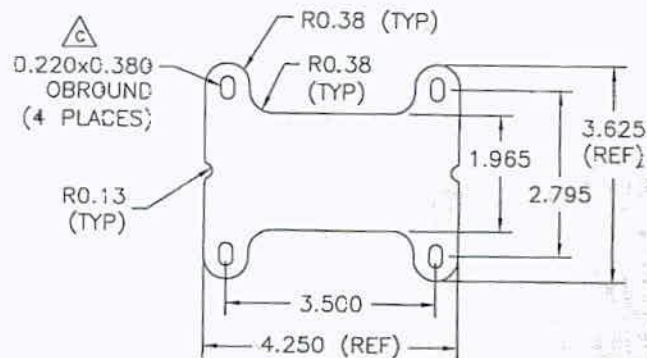
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/06	# 2.0	6 parts have a dim. of 3.600 instead of 3.625 P.C. water get cut too small.	PH 07.12.05 PDR 255042	Parts are acceptable this one time only. Acceptable edge distance remains based on E/D-1.5	IB 07-12-06	✓ 07/12/06	PH 07.12.05 PDR 255042	✓ 07/12/06

NOTE: Date & initial all entries

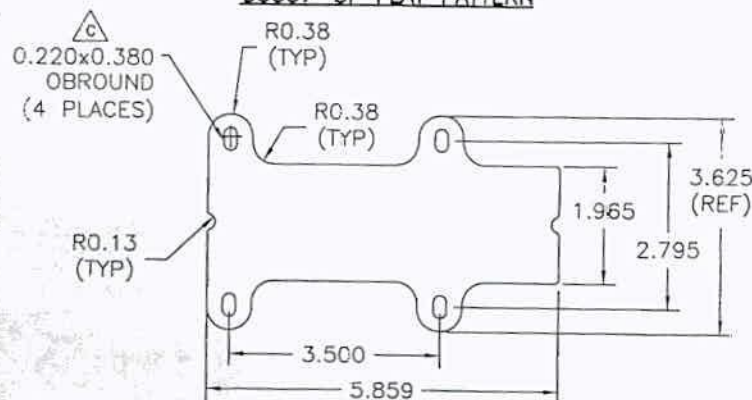
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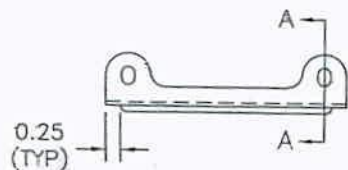
D3537-1F FLAT PATTERN



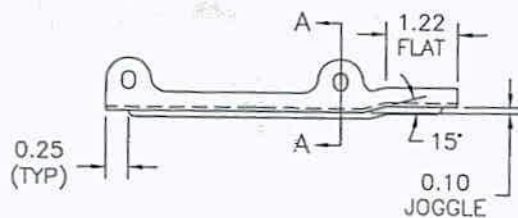
D3537-3F FLAT PATTERN



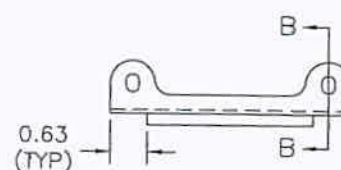
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



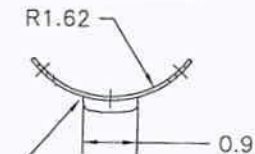
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

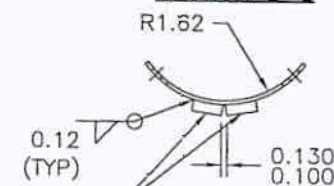


SECTION A-A



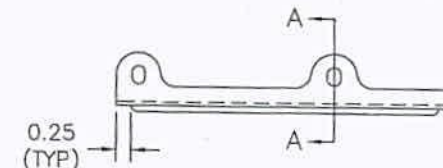
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

RELEASED
07-05-08
PER ECU
952

SHOP FOR
RETURN
ENGINEER
CONTROL
SUBJECT TO AN
INVESTIGATION
WITH CATTN
WORK ON
3/1/04

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